Work Order ID 63052

Tuesday, October 19, 2010 10:16:46 AM

Item ID: D3929-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Gusset Assembly

Start Date: 10/19/2010 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 10/26/2010 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** ✓ **Date:** 10-10-19 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3929 / Rev A									
100		0.00							
Waterjet	**Memo**	0.00				B10-10-21			
FLOW CNC Waterjet	1-Cut as per Dwg D3929 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B10-10-21			
Quality Control									

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo JM-03 A1272	0.00				6			10/27
Quality Control									
140		0.00							
Large Fab	Memo	0.00						10.10.28	
Large Fab	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch: 111585								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00	BE 10.10.28			6			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 63052

Tuesday, October 19, 2010 10:16:46 AM

Item ID: D3929-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Gusset Assembly

Start Date: 10/19/2010 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 10/26/2010 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location:	0.00							
	Memo	0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

8 solubs

(+6)

SAD 10-10-02

(6)

CK 10/11/03

CMF 10-10-2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Tuesday, October 19, 2010 10:16:50 AM

Work Order ID: 63052

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Start Date: 10/19/2010 **Required Date:** 10/26/2010

Start Qty: 6.00 **Required Qty:** 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	47.5523	0.45	2.842105	JB 10-10-21		
				Location			**Loc Qty**		**Loc Code**				
				MAT			47.5523						
					114799		47.5523			114799			
D3907-1 Bushing		Manufactured	No			130	Each	33.0000	2	12	6	10.10.27	
				Location			**Loc Qty**		**Loc Code**				
				WA			33						
					60720		5						
					62149		28			12			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	63052
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	.379	X		V IB02	
0.500	+/-0.010	.500	X		V	
0.500	+/-0.010	.500	X		V	
4.036	+/-0.010	4.036	X		T	
4.382	+/-0.010	4.382	X		T	
8.274	+/-0.010	8.274	X		T	
10.915	+/-0.010	10.914	X		V PRO IB02	
1.000	+/-0.010	1.009	X		V	
11.198	+/-0.010	11.198	X		T	
0.500	+/-0.010	.500	X		V	
1.572	+/-0.010	1.571	X		V	
0.125	+/-0.010	.117	X		V	

Measured by:	IB	Audited by:		Prototype Approval:	N/A
Date:	10-10-21	Date:	101021	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041/-042	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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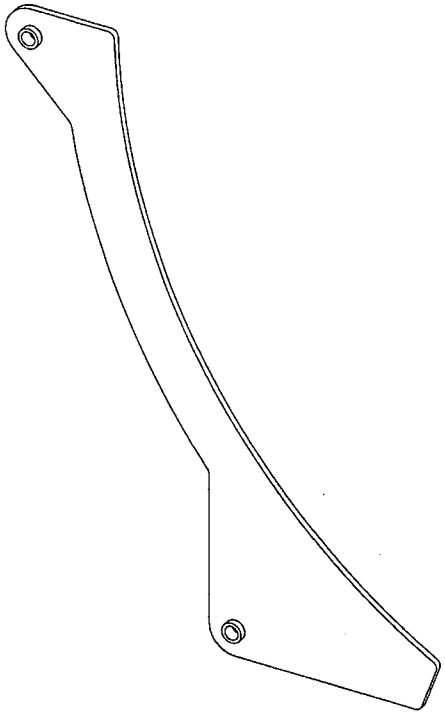
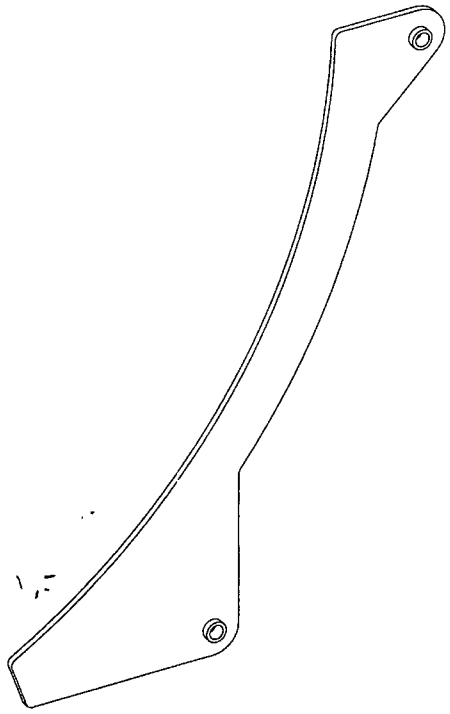
ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43052
10-10-09

RELEASED
09/04/22 MM

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	09.04.03

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3929	REV. A SHEET 1 OF 3
MFG. APPR.			
APPROVED		TITLE GUSSET ASSEMBLY	SCALE NTS
DE APPR.			
DATE 09.04.03			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

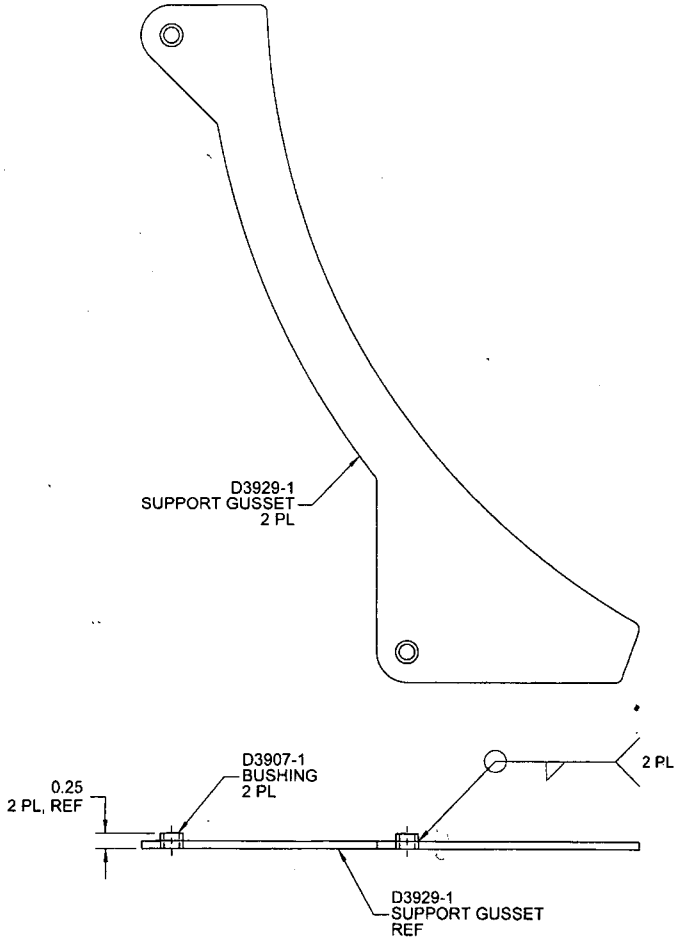
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

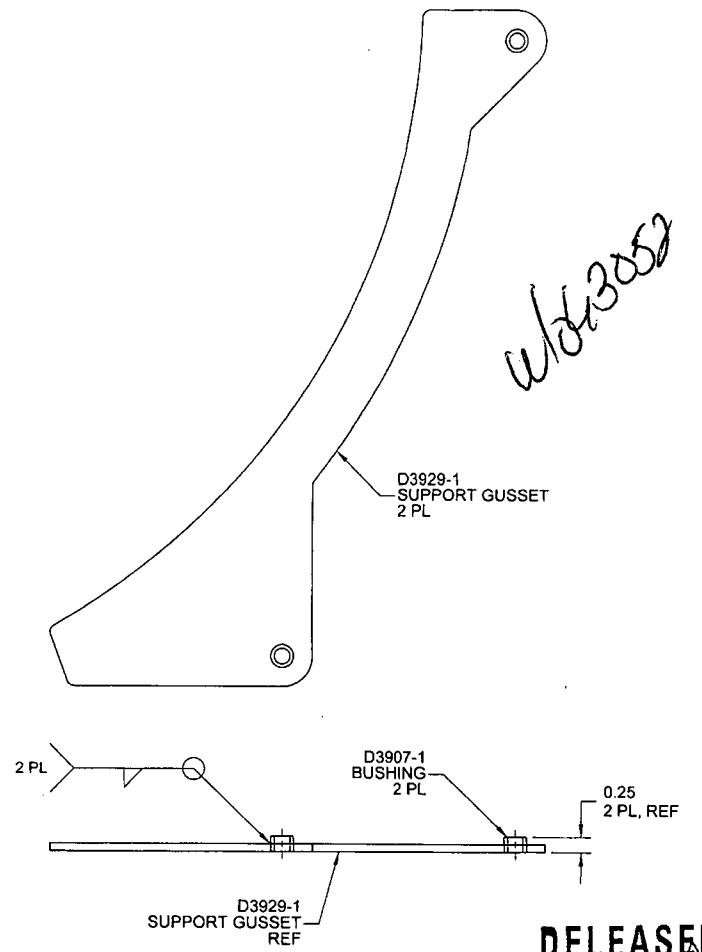
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

W/D43052

RELEASED 09/04/22

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3929 — REV. A — SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE GUSSET ASSEMBLY — SCALE NTS
DE APPR.		
DATE 09.04.03		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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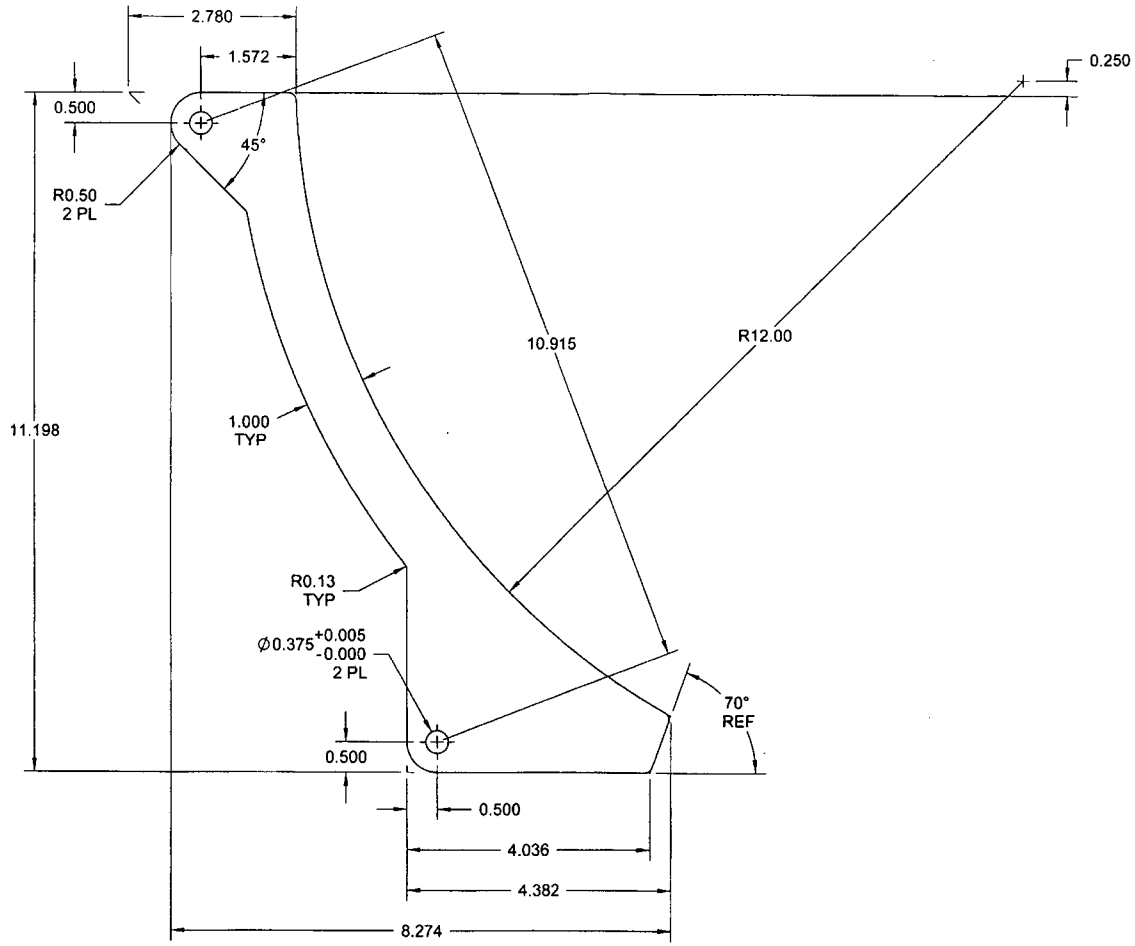
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D3929-1 SUPPORT GUSSET

W043052

RELEASED 9/04/22

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3929 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE: GUSSET ASSEMBLY — SCALE: NTS
DE APPR.		
DATE 09.04.03		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE